

Date: Monday, 11/6/2006 2:39:45 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : LUG EXTRUSION
Job Number : 29339
Estimate Number : 10326
P.O. Number : *N/A* Part Number : D27317
This Issue : 11/6/2006 S.O. No. : *N/A* Drawing Number : D2731 REV B
Prsht Rev. : NC Project Number : N/A
First Issue : 11/6/2006 Type : MACHINED PARTS Drawing Revision : B
Previous Run : 28936 Material : *N/A*
Written By : Due Date : 11/22/2006 Qty: 100 Um: Each
Checked & Approved By : *[Signature]*
Comment : Est D 00.95.19 Added inspect level 8, removed P/O powder coating EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D2423 Lug Extrusion



Comment: Qty.: 0.0717 f(s)/Unit Total: 7.1715 f(s)

Lug Extrusion D2423

Batch: *B23779**J.F. 06/11/07**(102)*

2.0 BAND SAW BAND SAW



Comment: BAND SAW

Cut D2423 extrusion to .82"

Batch *B23779 J.F. 06/11/07**(102)*

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine as per folio D2731-7.

2-Check for crack while loading into the machine.

3-Tumble

4-Deburr any rough edges after tumbling

*Issue P.O 2438**Machine per drawing D2731 Rev B**06/11/07**102*

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*Receive + Suspect for**tensile strength**(102)*

5.0 QC5 SECOND CHECK

Comment: SECOND CHECK *Inspect level 5**06-11-20**(102)*

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: PD Date: 06/11/12
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 11/6/2006 2:39:46 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG EXTRUSION

Job Number: 29339

Part Number: D27317

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

PL

06/11/22 X 102

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (ref. 4.3.5.1) per Dart QSI 005 4.3

PL

M102 391

06/11/27 X 102

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

PL 6/11/28 (102)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *5148*

PL 6/14/28 102

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

102
06/11/29

Job Completion



06/11/29

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

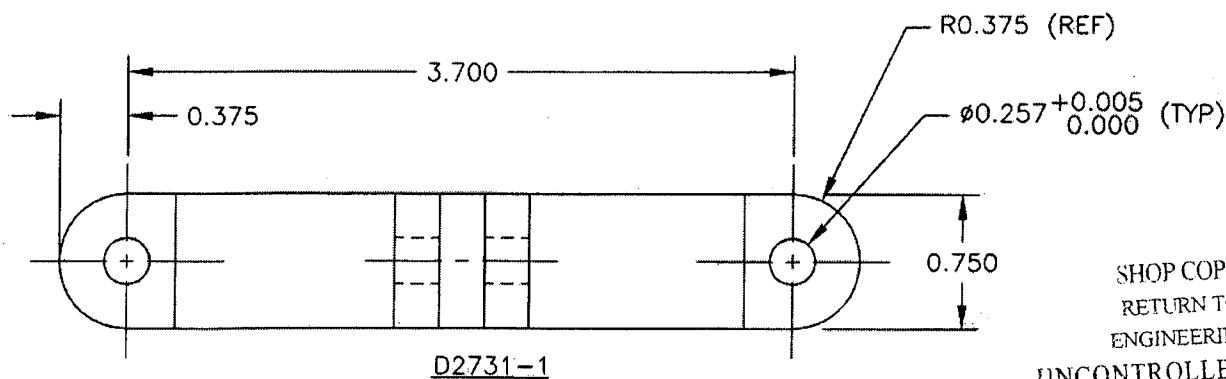
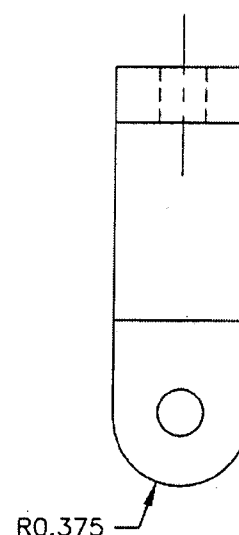
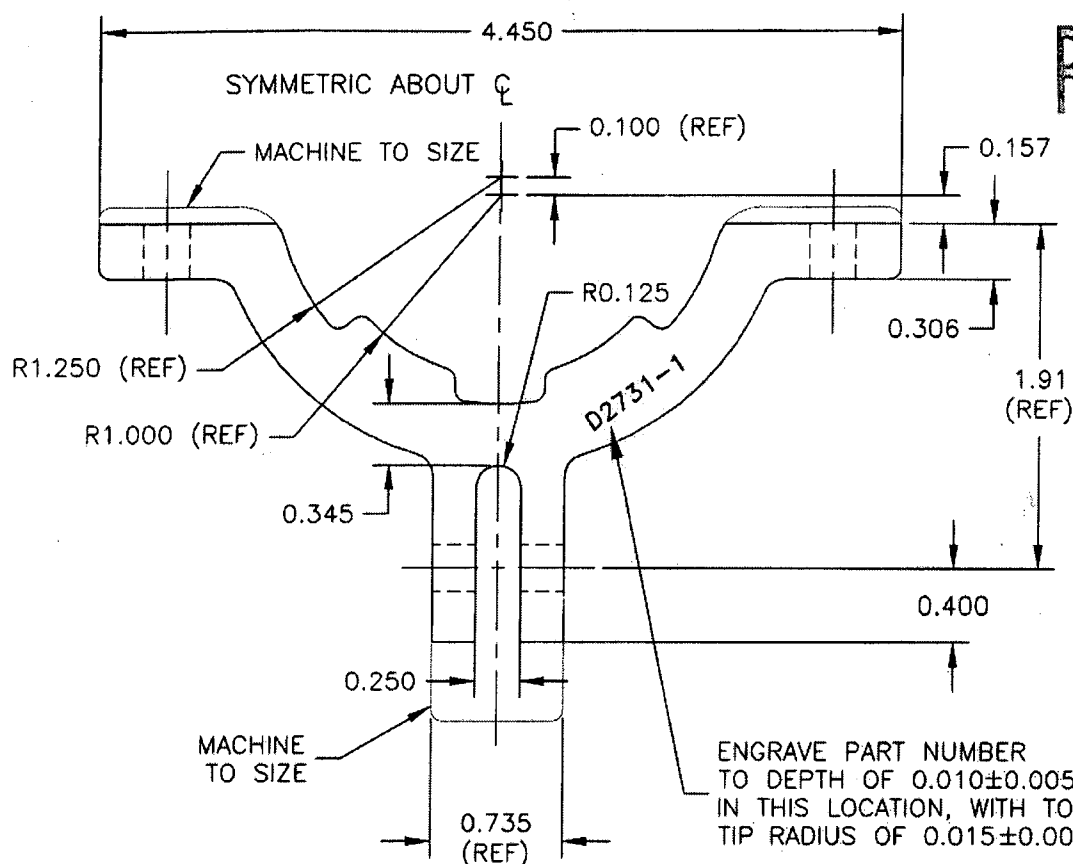
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries



DESIGN KE	DRAWN BY RF	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED KE	APPROVED [Signature]	DRAWING NO. D2731	REV. B SHEET 1 OF 4
DATE 99.07.06		TITLE MOUNTING LUG	SCALE 1:1
A	98.05.13	NEW ISSUE	
B	99.07.06	REVISED DIMENSIONS	



MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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WITHOUT NOTICE

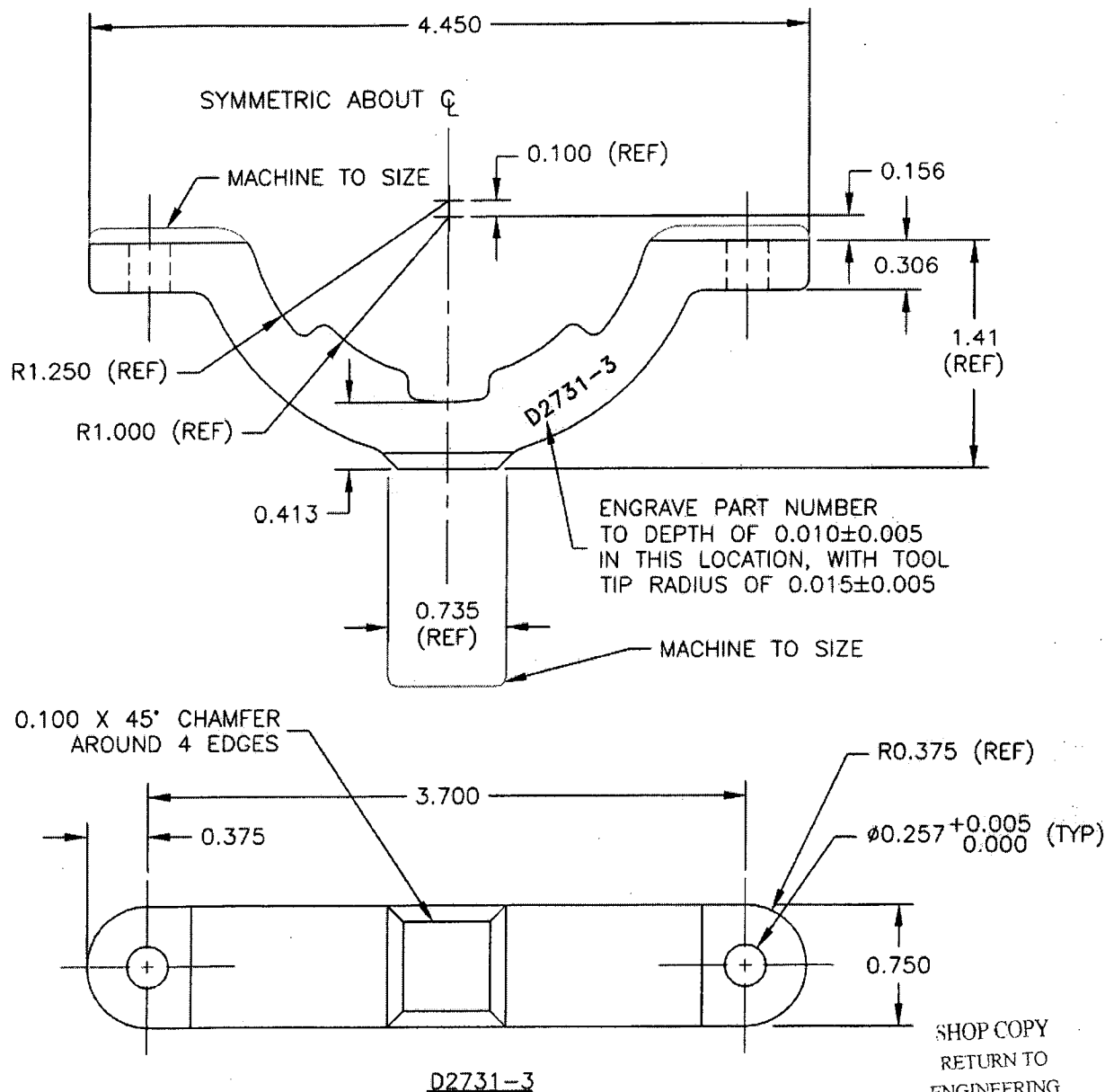
WORK ORDER
NO. 29339

NO. 2933



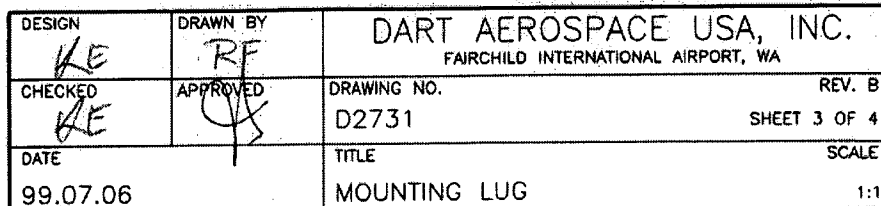
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CHECKED <i>KE</i>	APPROVED <i>Q</i>	DRAWING NO. D2731	REV. B SHEET 2 OF 4
DATE 99.07.06		TITLE MOUNTING LUG	SCALE 1:1

RELEASED
99.07.14 *KE*

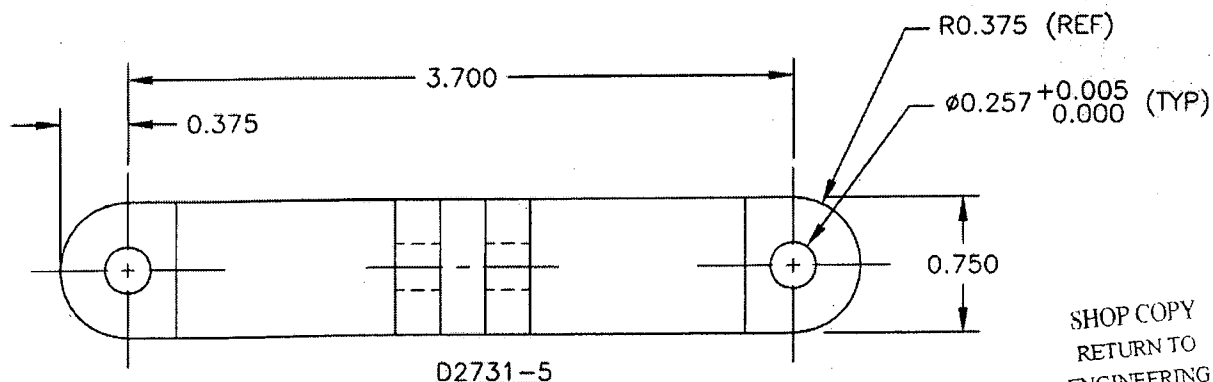
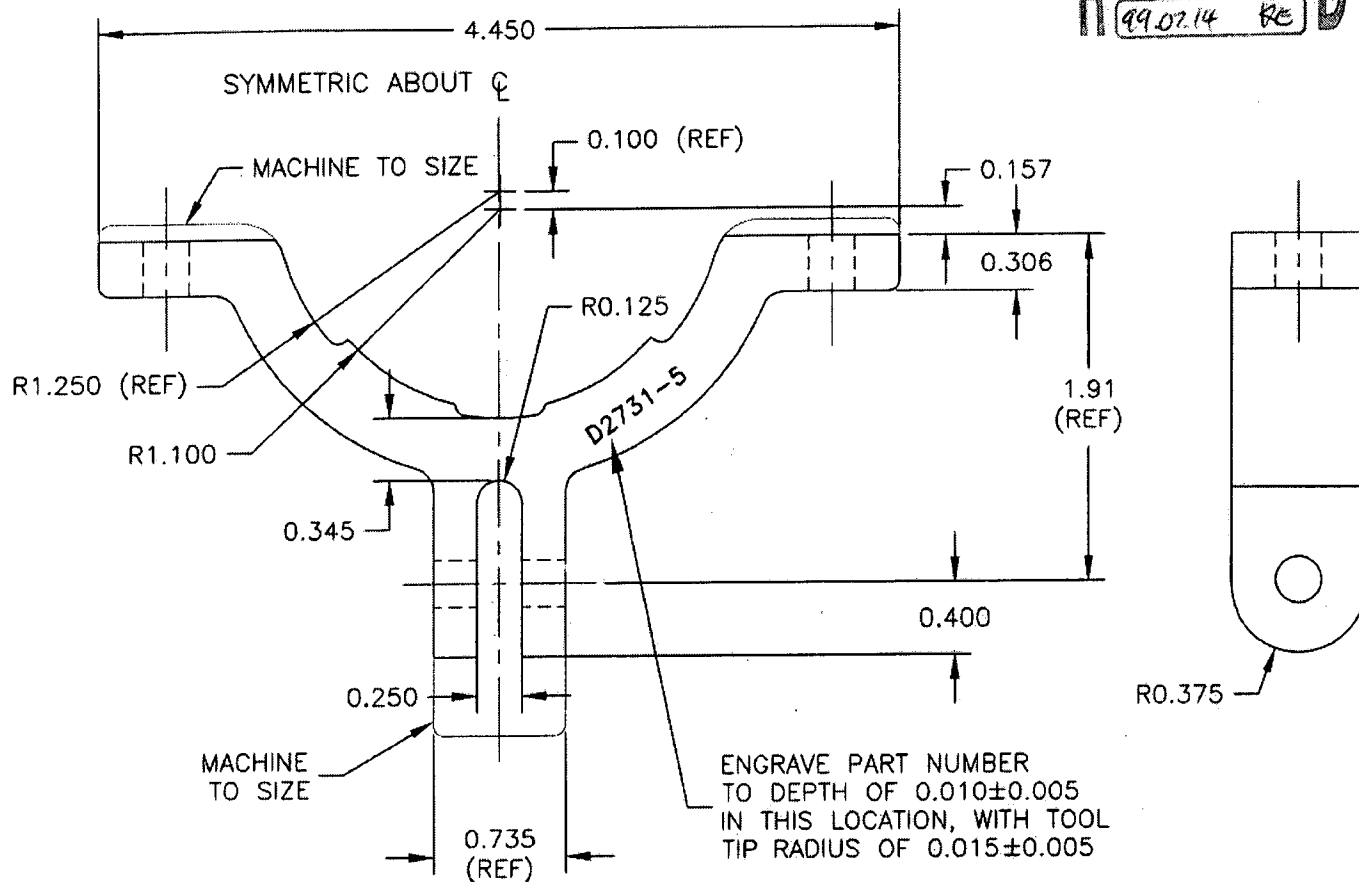


MAKE FROM EXTRUSION D2423
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99.07.14 RE

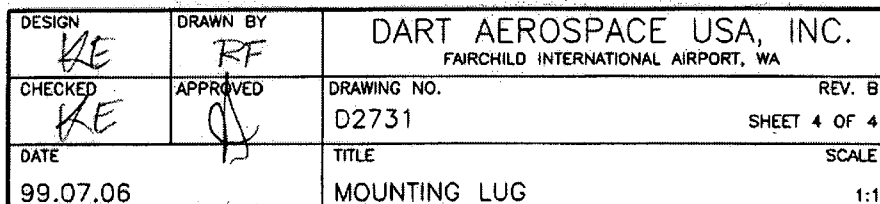


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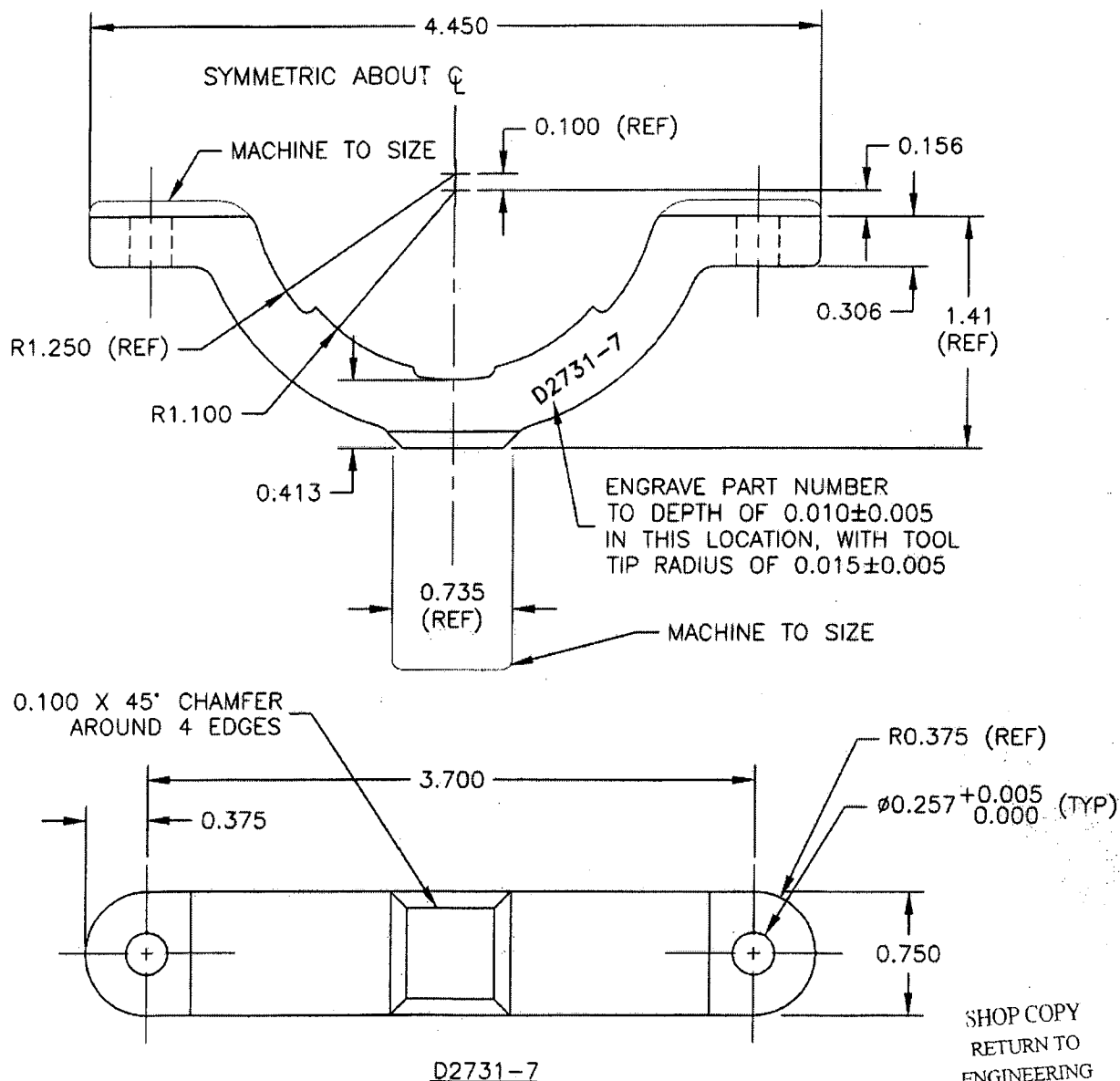
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NOTICE

3 WORK ORDER
TED. NO. 29339



RELEASED
99.07.14 KE



MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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WORK ORDER
NO. 29339



CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

QUANTITY

PART NUMBER

PART NAME

P.O. NUMBER

102 ✓

D2731-7 ✓


Lug

2438

MATERIAL: supplied by DART B29339 D2423 B23779 ✓

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.


Shigi (Regula) Walz

Vankleek Hill, November 17, 2006